

Date: Monday, 24/12/2007 12:12:22 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-642-611

Job Number : 35179

Estimate Number : 10804

P.O. Number :

Part Number : D206642611

This Issue : 24/12/2007 S.O. No. :

Drawing Number : RTN635.ECN1070

Prsht Rev. : NC

Project Number :

First Issue : 16/10/2007 Type : LANDING GEAR

Drawing Revision :

Previous Run : 00015

Material :

Due Date : 23/10/2007 Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

**DART**

TRANSPORT CANADA APPROVAL # 09-89

TEL: 1-613-632-3336  
FAX: 1-613-632-4443

P/N	D206-642-611	CHG	CHG002
DESC	Float Skidtube LH	STC	SH98-4
LOT	B31962	STC	SA00475SE
MODEL	Bell 206A/B	STC	

US PATENT # 5735484  
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 635

2.0 D206642611 Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Skidtube LH

ORIGINAL B/N 31962

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

a) Drill out existing mid float welded spacers. 3 spacers per skidtube

b) Fill drilled out holes with weld. 6 holes total

c) Drill new mid float bag holes (on an angle) per D3288 Rev F. 12

places per skidtube

Install  
plus  
and

M 100330

DP 8-1-15

(welding rod)

M 105671

BE 08/02/05

6061-T6

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

REMOVE ALL EXISTING PARTS  
SAND LIGHTLY FOR RE-PAINT

M-L 08/02/12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

POWDER COATING

POWDER COATING



M 107005



(IX)

Comment: POWDER COATING

RE-PAINT PER QSI005

M-L 08/02/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/02/13 (P)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.

e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places

INSTALL ALL EXISTING PARTS (WEARPLATES ETC):  
PER DRWG D3288 REV.F

INDICATE ANY NEW PARTS USED:

- NAS1515H3L x 2

m 106516

- D2646 B32427

- AN3C4A x 66

Batch: m 107008

- AN960C10L x 66

Batch: m 107008

- AN4C5A x 1

m 104936

- AN960C416 x 1

m 100993

FL 08/02/13 (P)

11.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)  
INSERT

B36319

FL 08/02/13 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/02/13		- Gasket D3536-15 x1 B33964 - Gasket D3536-21 x1 B31995 - Gasket D3536-35 x1 B36609 - Gasket D3536-41 x1 B31997	4/2	08/02/13		U	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

SCREW

(OR AN3C3A)

M107008

FL

13.0

AN960C10L

washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

washer

M107008

FL 08/02/13 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/14 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PICK NEW PACKING KIT:

16.0

D206651041

206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

1 D206-651-041 GHW Kit

Batch: 31296

AS 08/02/19 (X)

17.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description Batch

16 D2652

Bushing

37031

AS 08/02/19 (2)

18.0

D26651

Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2665-1

Saddle

35046

AS 08/02/19 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle

34859

AS

08/02/19

(X)

20.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

34628

AS

08/02/19

(X)

21.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

33497

AS

08/02/19

(X)

22.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

B31782

AS

08/02/19

(X)

23.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

B36336

B36336

AS

08/02/19

(X)

24.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M106541

AS

08/02/19

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

HIGH STEEL BOLT

batch

M106277

AS

08/02/19

(X1)

26.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

PHENOLIC WASHER

batch

M 34470

AS

08/02/19

(X1)

27.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

M100519

AS

08/02/19

(X1)

28.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C7A Bolt

M19185

AS

08/02/19

(X1)

29.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt

M100552

AS

08/02/19

(X1)

30.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt

M105746

AS

08/02/19

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D206-642-611

Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

1 AN5C35A Bolt M106551

8/3/27 50

32.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

bolt

batch M106576

AS 08/02/19 (X)

33.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

2 AN6C44A Bolt M10662

AS 08/02/19 (X)

34.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch M106176

AS 08/02/19 (X)

35.0

AN960C10L

washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN960C10L Washer M107008

AS 08/02/19 (X)

36.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M105793

AS 08/02/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D206-642-611

Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M103344

AS 08/02/19 (X1)

38.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt M19185

AS 08/02/19 (X1)

39.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M107214

New Patch

AS 08/02/22 (X1)

40.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M106763

AS 08/02/19 (X1)

41.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M105430

AS 08/02/19 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D206-642-611

Job Number: 35179

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut 103643

AS 08/02/19 (X)

43.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch M106167

AS 08/02/19 (X)

44.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch 36319

AS 08/02/19 (X)

45.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch B35522

AS 08/02/19 (X)

46.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch 35521

AS 08/02/19 (X)

47.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch B34471

AS 08/02/19 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

SCREW

batch

M106574

AS 08/02/19

(X)

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/27 (+)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

USING NEW B/N

CHG 003

Location:

83

PPP Rev:

B

8/3/27

50

(R)

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/02

Job Completion



W 08.03.31

35179

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## L Lacelle

**From:** Peter Hum [phum@dartaero.com]  
**Sent:** December 21, 2007 11:33 AM  
**To:** 'L Lacelle'  
**Subject:** RE: ECN1070 / 1063 for change record #003

Hi Linda,

I am writing this re-work with the assumption that the float skidtubes are painted and basically complete per the old CHG

Therefore to re-work these to CHG 003

- a) Drill out existing mid float welded spacers. 3 spacers per skidtube
- b) Fill drilled out holes with weld. 6 holes total
- c) Drill new mid float bag holes (on an angle) per D3288 Rev F. 12 places per skidtube
- d) Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.
- e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places

Changes to "pick" kit

- a) REMOVE NAS1515H5 washer replace with D3672-5. Qty 16
- b) REMOVE NAS1515H5L washer replace with D3672-7. Qty 8
- c) REMOVE NAS1515H4L washer replace with D3672-3. Qty 24
- d) ADD MS21250-03004 bolt. Qty 6
- e) REMOVE NAS1515H3L washer replace with D3672-1. Qty 18
- f) ADD AN960JD10 washer. Qty 6

For reference please see D3288 Rev. F and Installation Instructions D206-642 Rev. I

Peter

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]  
Sent: December 20, 2007 2:46 PM  
To: Peter Hum (Peter Hum)  
Subject: FW: ECN1070 / 1063 for change record #003

Peter,

Could you please let me know what the rework scheme will be...642-641's returned from airlog/offshore

Thx  
LL

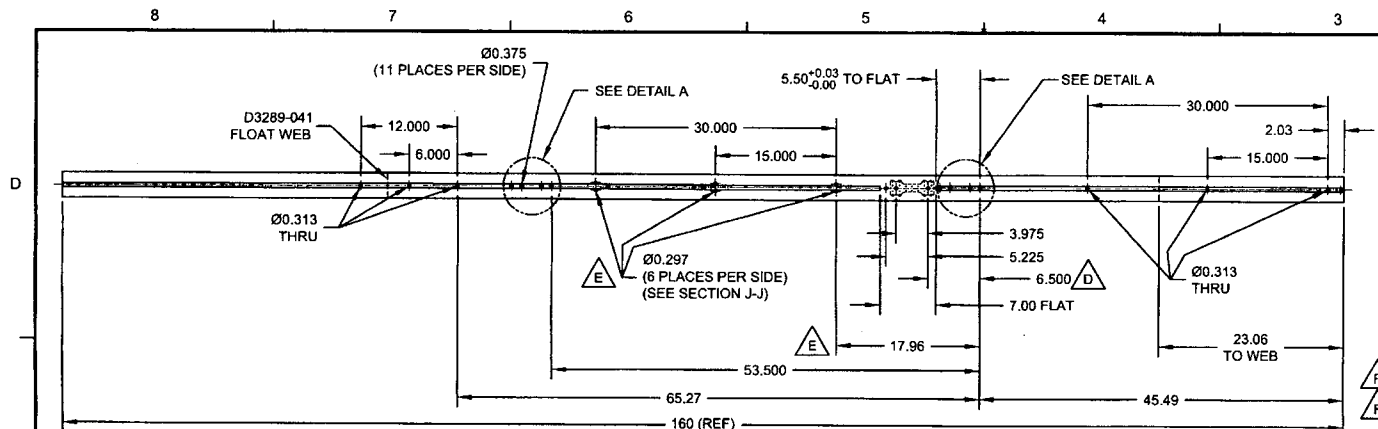
-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]  
Sent: December 20, 2007 1:50 PM  
To: Linda Lacelle (E-mail)  
Subject: ECN1070 / 1063 for change record #003

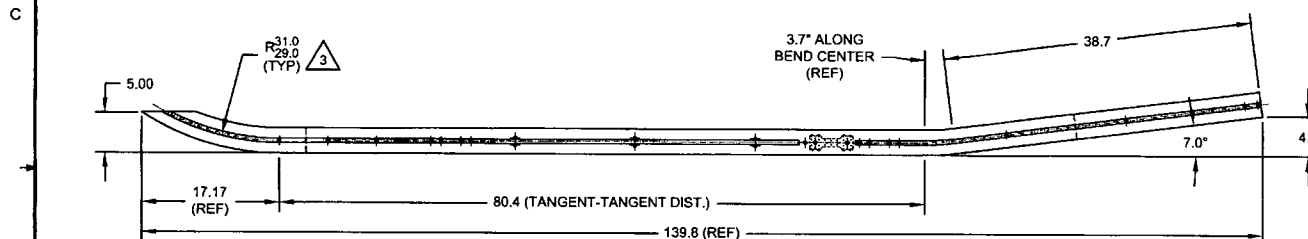
Linda,

All four skidtubes need to be reworked, B35179, 35180, 36159, 36160 per ecn 1070

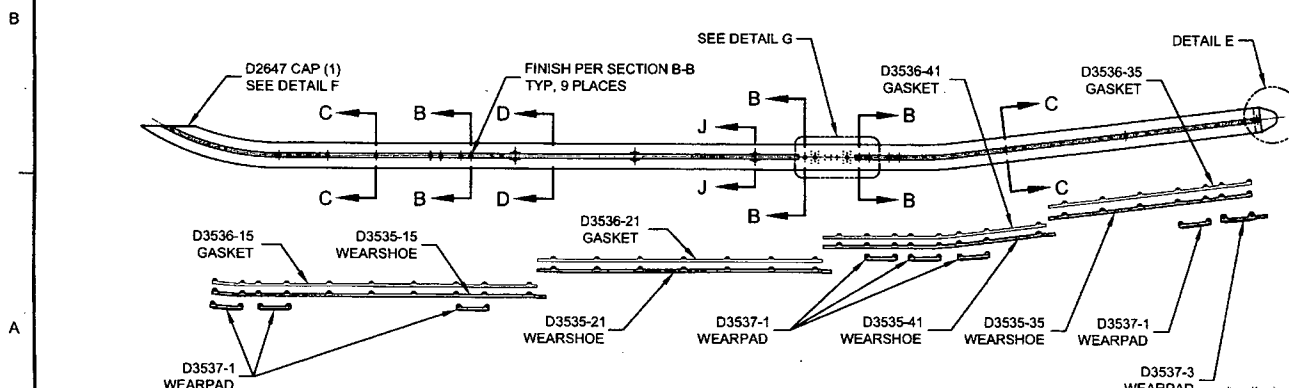
Kim Johnston  
Dart Aerospace Ltd.  
Engineering Clerk  
Document Control  
Email: kjohnston@dartaero.com  
Tel: 612 622 5200



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**



**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

Qty	Part Number	Description
1	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN50C416	WASHER
78	AN50C10L	WASHER
2	CR2045S3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

**GENERAL NOTES:**

- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3288-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES.
- DRILL 0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
- DRILL 0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- WELDING: PER DART QSI 004.

F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	REP		
APPROVED	REP		
DE APPR.	REP		
DATE	07.11.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY SCALE 1:15 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

67532  
07/12/19

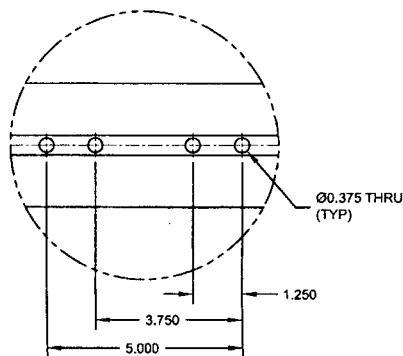
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

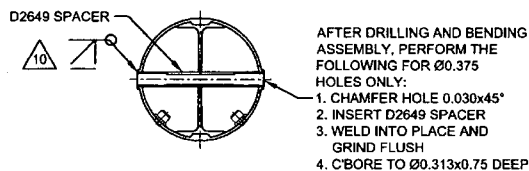
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

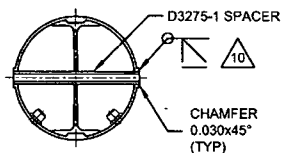
**NOTE:** Date & initial all entries



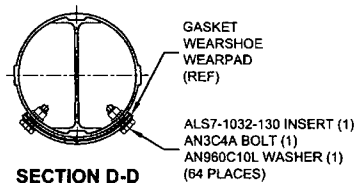
**DETAIL A: DRILL DETAIL**



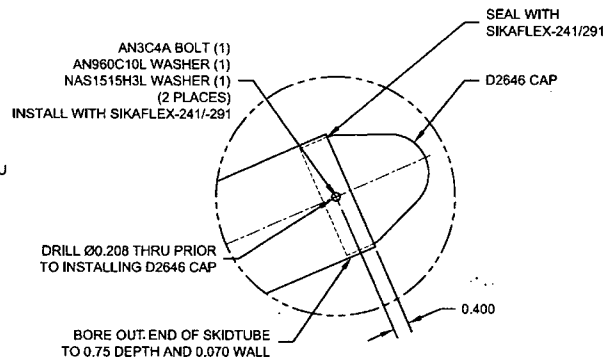
**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



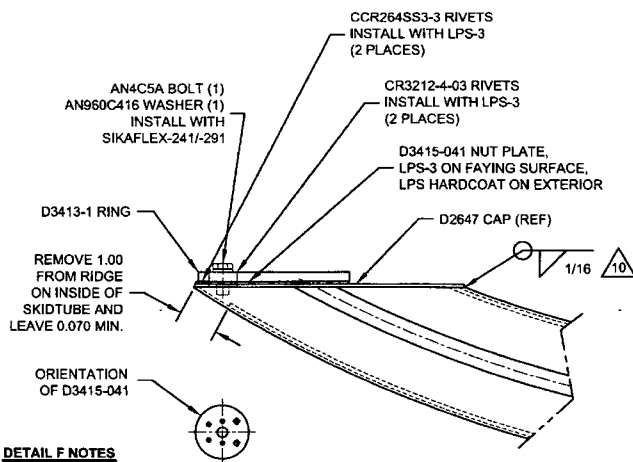
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



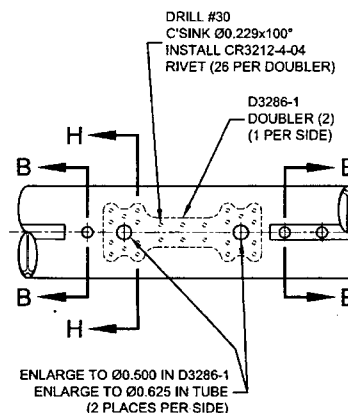
**DETAIL E**



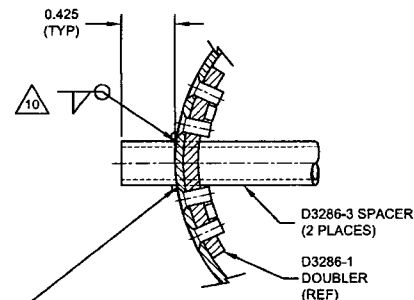
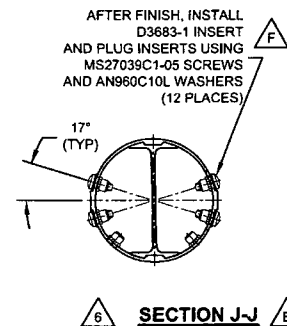
**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION H-H**  
NOT TO SCALE

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	3	D3288	SHEET 2 OF 2
APPROVED	4	TITLE	SCALE
DE APPR.	4	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

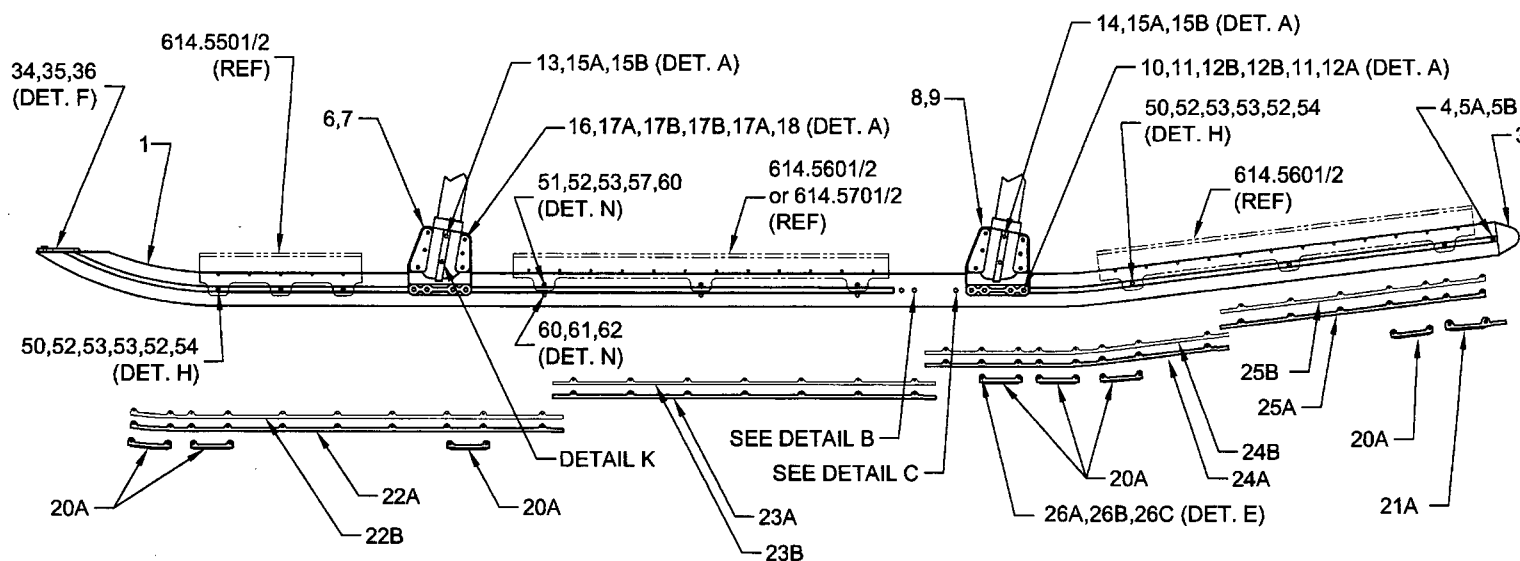
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

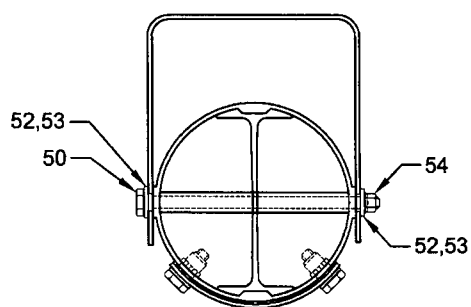
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

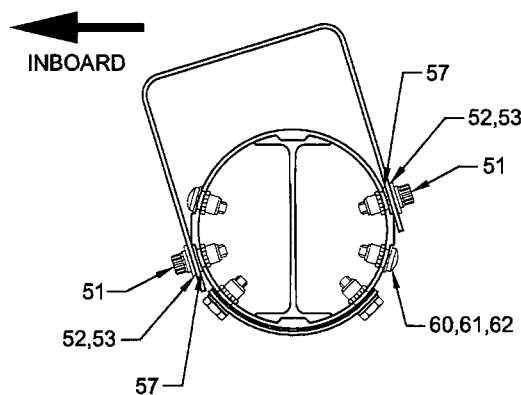
# **206 A/B FLOAT SKIDTUBES (TRI-BAG FLOATS)** (D206-642-611/-612/-613/-614)



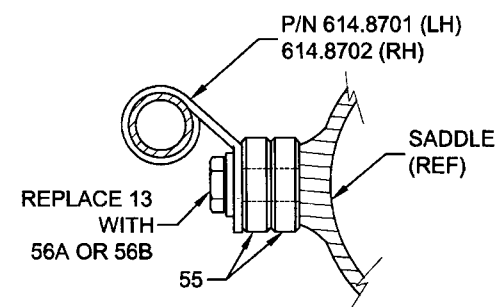
**DETAIL H**



**DETAIL N**



**DETAIL K**



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Revision: **L**  
Date: 07.10.25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

43

Date: Monday, 1/7/2008 8:47:05 AM  
User: Kim Johnston

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-611
Job Number	: 35179		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206642611
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: RTN635.ECN1070
Prsht Rev.	: NC	Project Number	:
First Issue	: 10/16/2007 Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 10/23/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



*Blueprints - 08.01.17*

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

46.0	D36725	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
PHENOLIC WASHER  
batch \_\_\_\_\_

47.0	D36723	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)  
PHENOLIC WASHER  
batch \_\_\_\_\_

48.0	MS27039C105	SCREW
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
SCREW  
batch \_\_\_\_\_

49.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**REFERENCE ONLY**

Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D206-642-611  
USING NEW B/N  
CHG 003  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_